

Date: Wednesday, 1/11/2006 4:30:47 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 25483		
Estimate Number	: 10104		
P.O. Number	: N/A	Part Number	: D2012107
This Issue	: 1/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2012-107 REV. C
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: C
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/31/2006
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	100 Um: Each
Comment	: Est: D 01.11.08 Re-format, Drawing to Rev. C SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 377

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per DXF File

Material release note is required.

U 06-01-12 100

2.0	D2012107F	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 CLEVIS

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

CL 06/02/01 109

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06-02-06

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

DL 06/02/08

110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 17 Date: 06/02/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 25483

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

DL 06/02/08

(110)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06/02/09 110

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 16

CY 06/02/09

(110)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/15

(110)

06/02/10 110

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SP Date: 06/02/10
 QA: N/C Closed: _____ Date: _____

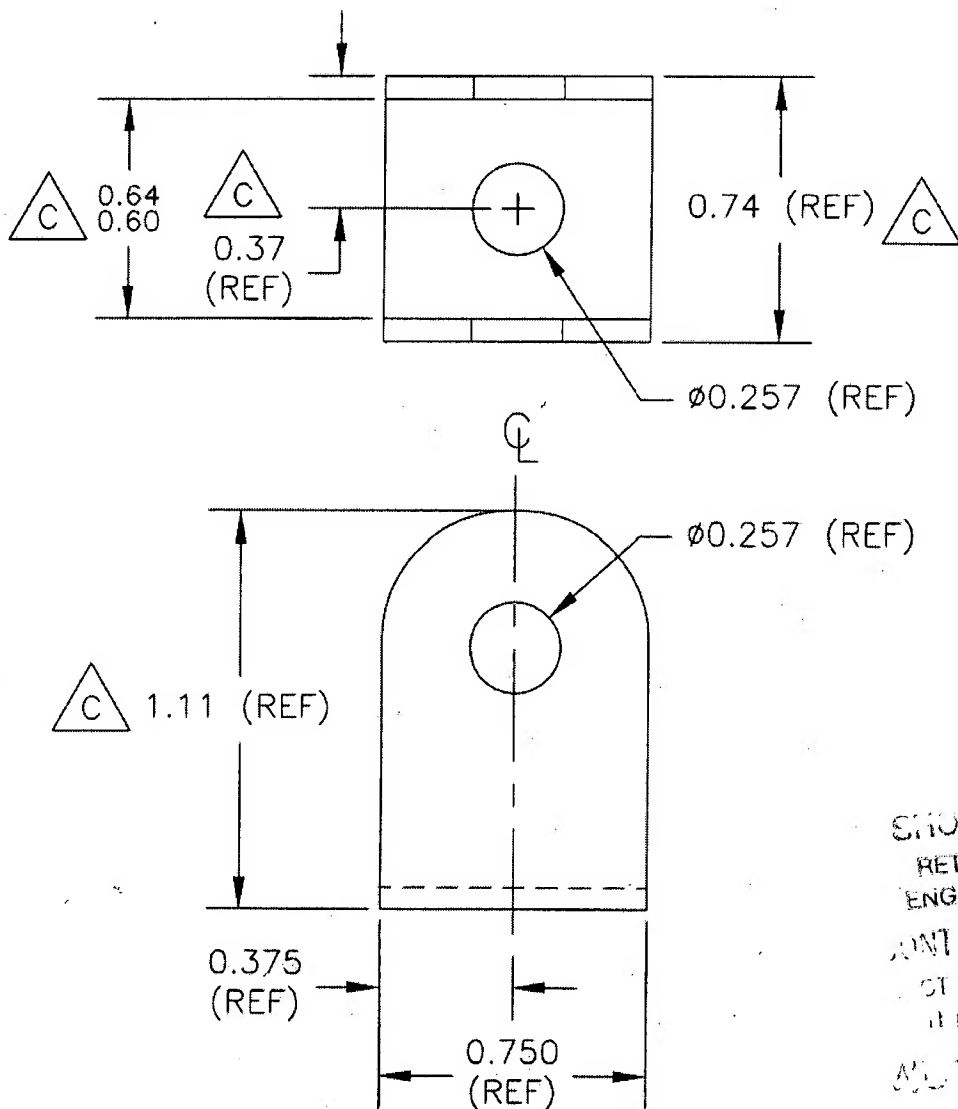
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED
00.01.04 PS

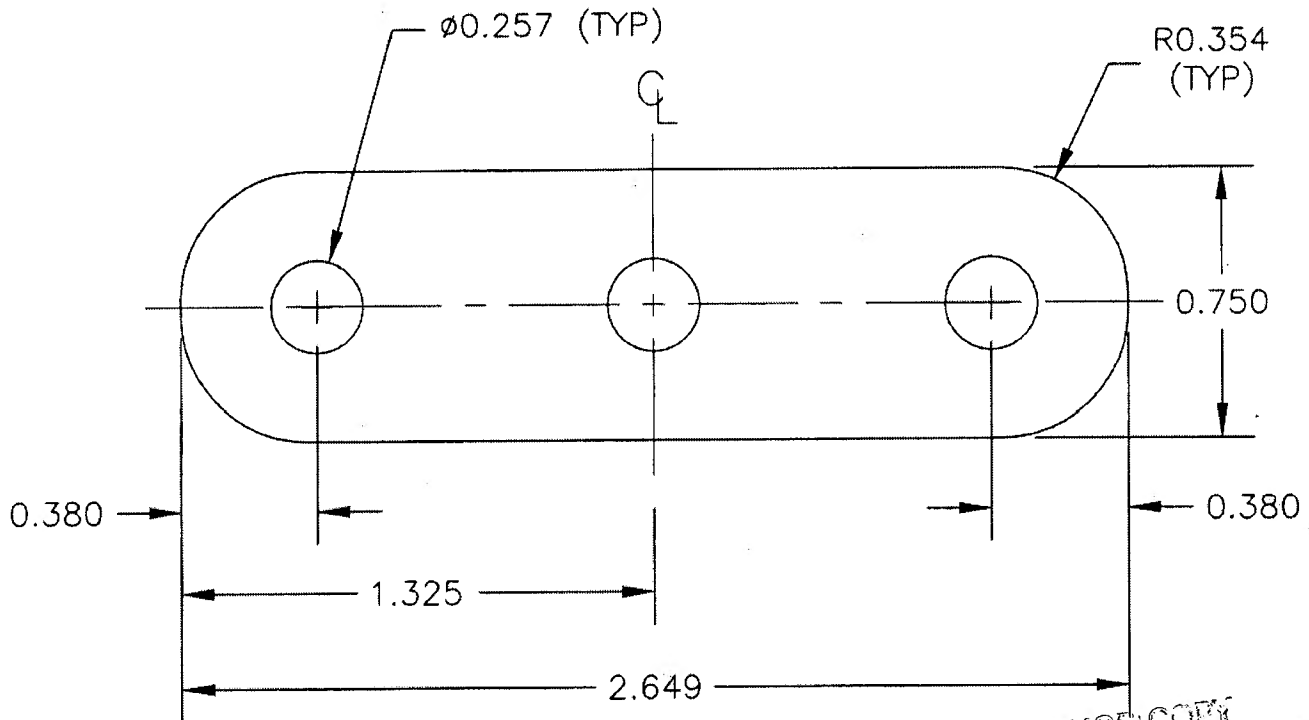


MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED
00-01-04 DS



D2012-107 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITH

W/O

25483

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

OCT-21-2004 15:59

MARUBENI-ITOCHU STEEL

684 669 0529

P.07/09



Certified in accordance to Pressure Equipment Directive 97/23/EC Annex 1,
Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No.0035)
Inspection Certificate EN10204-3.1B

Taiyuan Iron and Steel(Group)Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China

TEL: (0351)3013328 FAX: (0351)3017816

http://www.tisco.com.cn

E-mail: tgbxg@tisco.com.cn

INSPECTION CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480-02	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	20040941	
DATE OF ISSUE	/ /	

CUSTOMER

Marubeni-Itochu Steel CA.

CONTRACT NO.

P40824PC001

DATA OF

2004/09/20

Product**Melting furnace****Inspector's stamp****Mark of the Manufacturer**

COIL

E+VOD



Shanxi Taiyuan Stainless Steel Co., Ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions			Weight (kg)
1	4402727	4A7-310-4ZJ	1	0.0461	x 48	x C	7325
2	4402727	4A7-309-4ZJ	1	0.0461	x 48	x C .0500	7280
3	4402738	4A7-373-4ZY	1	0.0461	x 48	x C	7350
4	4402925	4A8-118-4ZD	1	0.0721	x 48	x C	7694
5	4402924	4A8-116-4ZY	1	0.0721	x 48	x C .0780	8801
6	4402933	4A8-154-3ZB	1	0.0721	x 48	x C	7515
7	4402923	4A8-157-3ZB	1	0.0981	x 48	x C .1090	7246

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4402727	0.050	0.450	1.370	0.022	0.002	18.070	8.120				
4402727	0.050	0.450	1.370	0.022	0.002	18.070	8.120				
4402738	0.050	0.460	1.360	0.019	0.002	18.100	8.100				
4402925	0.060	0.470	1.390	0.019	0.002	18.180	8.130				
4402924	0.060	0.480	1.380	0.019	0.002	18.180	8.130				
4402933	0.050	0.520	1.440	0.019	0.003	18.160	8.020				
4402923	0.050	0.460	1.340	0.020	0.004	18.140	8.210				

Mechanical Properties

Test No.	Tensile R.m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation A ₅ %	Corrosion Tests	Hardness		
						HRB	HV	HRC
4402727-T	655	270		66		86		
4402727-T	655	270		66		86		
4402738-T	650	255		66.5		86		
4402925-T	630	235		60		86		
4402924-T	655	255		63		85		
4402933-T	630	245		66.5		82		
4402923-T	650	265		57.5		85		

Surface and dimensions controlled: O.K.

Work Inspector:



P40824PC001

Page: 1 of 2

P40824PC001.

Jacob

16 ga 304 2B S.S

